

Work Order ID 58372-*split*

May 4, 2010 3:17:15 PM



Page 1

Item ID: D212-580-041

Accept



Setup Start



Revision ID:

Item Name: Cargo Mirror Assembly

Stop



Start Date: 04/05/2010 Start Qty: 6.00



Required Date: 13/05/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-5-04* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2161

Rev B2

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels as per PPP D212-580-041 CHG003

*S 10/6/04*

*for CL 10/06/04*

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg D2161 Identify as D2161-212 A/R SS ROD Batch: *M108160*

*10-6-3 (x4)*

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*S 10/6/03*

*(+4)*

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Page 2

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QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

④ 10.06.03

140

Black Sandtex(Ref:4.3.5.7) per QSI005.4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:15pm  
FINISH TIME: 3:45pm

OVEN TEMPERATURE: 320°C

72U 10/06/03

4

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 10 06 03 ④

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May 4, 2010 3:17:15 PM



Page 3

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Packaging

Pick Kit

0.00

Memo

0.00

= 7 m. 10/06/03

4X

Packaging

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/06/04

4X

180



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D212-580-041 Location: \_\_\_\_\_ PPP Rev: G

P 10/6/4 4



**Work Order ID 58372**

May 4, 2010 3:17:15 PM



Page 4

Item ID: D212-580-041

Accept



Setup Start



Revision ID:

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Stop



Start Date: 04/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/07 *[Signature]*  
MF  
10-6-7

# Picklist Print

May 4, 2010 3:17:19 PM

Page 1

Work Order ID: 58372

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly


Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS27039-1-08 		Purchased	No			100	Each	1,474.000	4			
Screw												

## Location

## Loc Qty

## Loc Code

ST291

1474

110552

44

110835

1430

D2013-3

Manufactured No

110

Each

0.0000

1



Mirror Bracket LH, 212

B58370 x4

D2013-4

Manufactured No

110

Each

0.0000

1



Mirror Bracket RH, 212

B58371 x4

CCR264SS3-2

Purchased No

170

Each

232.0000

4



Rivet, Cherry

## Location

## Loc Qty

## Loc Code

ST311

232

106578

45

108738

87

112314

100

D2011-103

Manufactured No

170

Each

13.0000

2



8" Mirror

## Location

## Loc Qty

## Loc Code

ST226

13

52198

13

10/06/03

16x m-l

10-6-2

10-6-2

16x m-l

10/06/03

8x m-l

10/06/03

# Picklist Print

May 4, 2010 3:17:19 PM

Page 2

Work Order ID: 58372

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2037-101		Manufactured	No			170	Each	10.0000	1			
												
Arm												

Location Loc Qty Loc Code

WA 10  
52272 10

MS21059L3		Purchased	No			170	Each	72.0000	2			
												
Nut Plate												

Location Loc Qty Loc Code

ST302 72  
113749 10  
114456 62

8x m.d  
10/06/03

May 4, 2010 3:17:19 PM

Shop Packet Print

Page 2

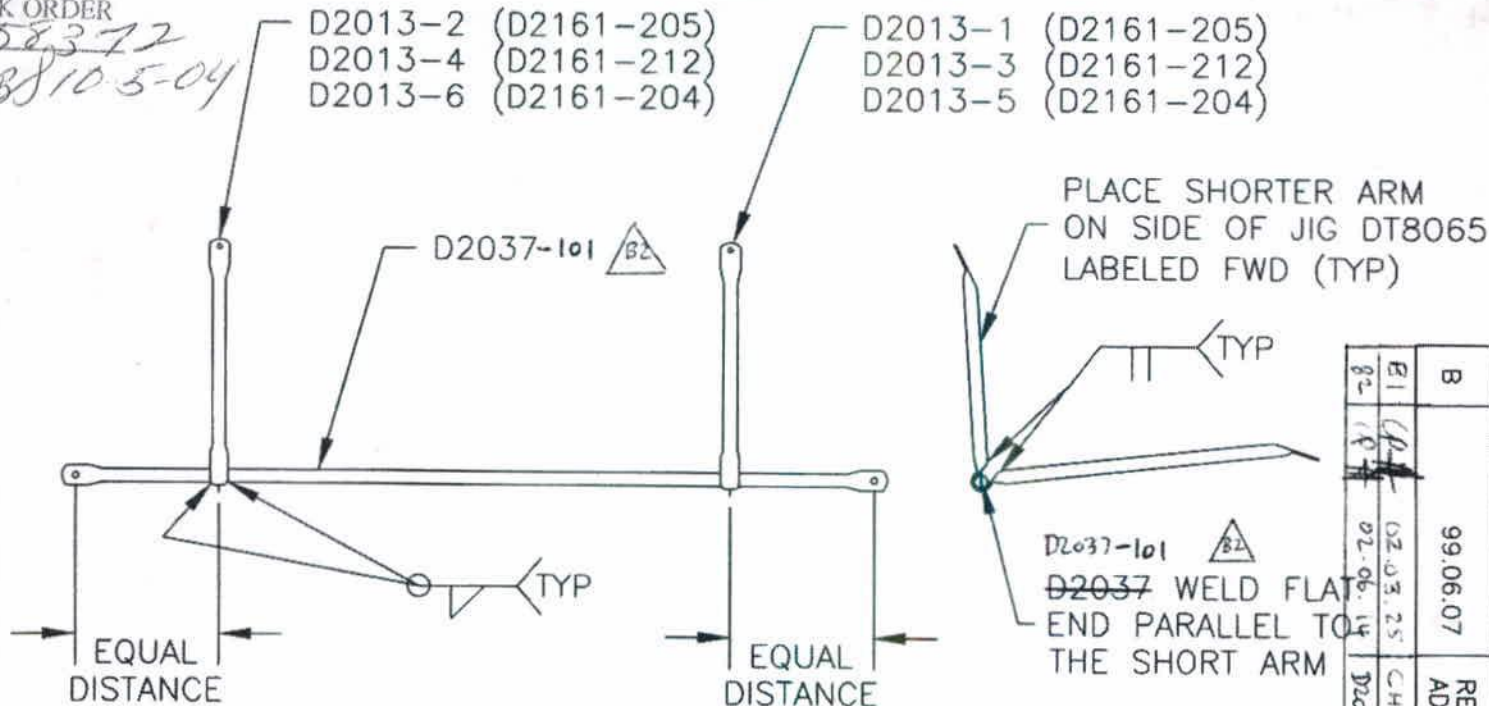


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 58372  
BS105-04

D2013-2 (D2161-205)  
D2013-4 (D2161-212)  
D2013-6 (D2161-204)

D2013-1 (D2161-205)  
D2013-3 (D2161-212)  
D2013-5 (D2161-204)



DETAIL OF D2161-204  
DETAIL OF D2161-205  
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY  
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~  
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER  
DART QSI 005 4.3 (B)

**DART**



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DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	RT	D2161
DATE	TITLE	SCALE
99.06.07	MIRROR BRACKET	NTS
REV.	DATE	DESCRIPTION
A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 WELD

RELEASED  
KE 99.06.10

## 25.4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D204-562-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D205-563-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D212-580-041	5.0 lb	0 in	0 lb-in	-5.25 in	-26.3 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	-0.13 m	-0.30 m-kg

## 25.5 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D2011-103	MIRROR
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		4	CCR264SS-3-2	RIVET, BLIND
		2	MS21059L3	NUTPLATE
4	4	4	MS27039-1-08	SCREW

\* PARTS ARE INCLUDED WITH D2011-103 MIRROR



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries